

Work Order ID 66013

Tuesday, February 01, 2011 3:24:13 PM



HAI Daryl Page 1

Item ID: D4068-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Curved Wearplate

Start Date: 2/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-02-01 Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4068	A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut D4068-1 as per Dwg D4068

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

B11-2-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B11-2-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66013

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Item ID: D4068-041

Accept

Revision ID:

Item Name: Curved Wearplate

Start Date: 2/1/2011 Start Qty: 1.00

Required Date: 2/15/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 11/02/02

72

130

Form as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 11/02/09

2

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml

11

02

08

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D4068-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Curved Wearplate					
Start Date:	2/1/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/15/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>M 116787</u> Memo	0.00				<u>EL</u>	<u>11-2-9.</u>		
160 QC Quality Control	<u>QC10</u> QC9 Inspect visual per QSI004- Fusion Welds Memo	0.00		<u>Sub 2/10</u>					
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00		<u>Sub 2/10</u>		<u>(F2)</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66013

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Item ID: D4068-041

Accept



Setup Start



Revision ID:

Item Name: Curved Wearplate

Stop



Start Date: 2/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M112588.

0.00

Memo

0.00

POWDER COAT:

Start Time: *8:35*

Oven Temperature: *320°*

Finish Time: *8:05*

2

BR 11-02-10

190



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

2

6 AL 11/02/10

200



Packaging

Packaging

Identify as per dwg & Stock Location: *S7498*

Memo

0.00

0.00

Ref 1/3/01 (2)

Work Order ID 66013

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Start Date: 2/1/2011 Start Qty: 1.00

Required Date: 2/15/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/01
C2 11/03/01

Picklist Print

Tuesday, February 01, 2011 3:24:10 PM

Page 1

Work Order ID: 66013



Parent Item: D4068-041



Parent Item Name: Curved Wearplate


Start Date: 2/1/2011

Required Date: 2/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA  304SS sheet .080		Purchased	No			100	sf	73.3108	0.3742	0.393895			



H3 11-2-2

Location

Loc Qty

Loc Code

MAT20

73.3108

113295

73.3108

113245

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

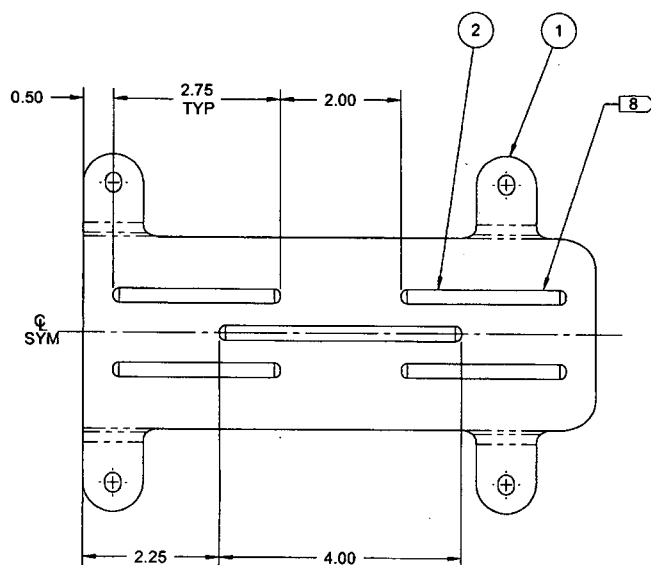
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

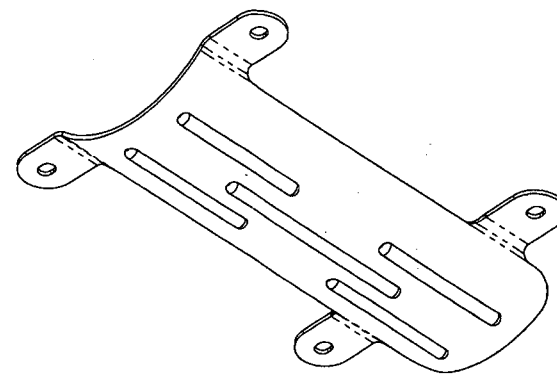
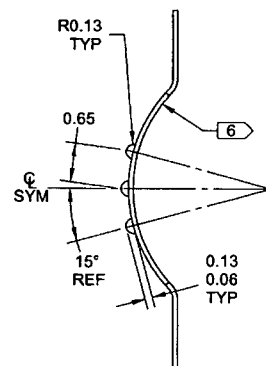
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4068-041	412 CURVED WEARPLATE
1	1	D4068-1	PLATE
2	A/R	2059B	HARDCOAT



D4068-041 412 CURVED WEARPLATE



#66013

RELEASED
2010-04-07
MP

D4068-041 NOTES:

- 1) MATERIAL: SEE SHEET 3
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4068-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.87 lbs
- 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.31		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4068** REV. A
SHEET 1 OF 3
TITLE **412 CURVED WEARPLATE** SCALE NTS

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